

**Work Order ID 61913**

Page 1

Thursday, September 09, 2010 1:16:04 PM

Item ID: D350-636-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 9/9/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/17/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *K*Date: *10-9-09*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo *X*

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 005

*HJ for BG 10-10-07**8/10/10/00*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
Skidtubes	<b>Memo</b>	0.00							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.								
	4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting								
	5- Drill fwd step holes using DT9616. Ensure proper positioning.								
	6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)								
	➤ ***ONLY DRILL ONE SIDE OF FWD SADDLE HOLES USING DT8150***								
	7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.								
	***SECOND SIDE***								
	➤ 8- Clecko DT9642 and drill fwd saddle holes on second side, ensure proper positioning.								
	9-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail C to 0.500" (8 holes per side)								
	10-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to								

DP 10-9-16

DP 10-9-24

W/O:		WORK ORDER CHANGES					
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Page 5

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Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)  
as per dwg D2750.2-Open up holes of Detail B to 0.750" (total of 4 holes per side)  
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750  
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐☐☐ Sikaflex-291 batch: M115114☐☐  
exp. date: 11-1-308- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004  
(welding instructions on sheet 8)A/R ☐☐☐ Aluminum Rod batch: M114877

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

10-Grind welds flush as per.Dwg D2750

  
10-9-24

BE 10-9-27  
BE 10-9-27  
SAD  
10-09-27

PTO

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-636-011 PAR #: \_\_\_\_\_ Fault Category: Skitch NCR: Yes No DQA: 2 Date: 10/10/22  
 Resolution: rework Disposition: rework QA: N/C Closed: ju Date: 10/10/22

NCR: <u>61913</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10-9-27	160	1ST FRONT HOLE DETAIL B BACKDRILLED WITH .625 DRILL BIT INSTEAD OF .5937 R.C. welder <del>was</del> pulled	<u>[Signature]</u>	- Drill out 1st hole x-bolt spacer + remove → weld in D3490-3 at 71	BE 10-9-27	<u>[Signature]</u> 10/10/22	<u>[Signature]</u>	<u>[Signature]</u> 10/10/27
		wrong x-bolt spacer to check drill bit size. Human error/LOA	<u>[Signature]</u>	B# <u>61218</u> as per ASTM 4	BE 10-9-27	<u>[Signature]</u> 10/10/22	<u>[Signature]</u>	<u>[Signature]</u> 10/10/27

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Page 6

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Customer:

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Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp11-Spot face ground handling holes section (total of 4 places per side) as per  
dwg D2750SAD BE  
10-09-27

①

12-Deburr holes

BE 10/09/28

170

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

S 10/09/28

④

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/09/28

④

W/O:		WORK ORDER CHANGES					
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Page 7

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Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

Pressure Wash per QSI005 4.3

0.00

=) MU 10/09/30

1

0



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

BK 10-10-11



Powdercoat

M115291.

Memo

0.00

1

0

Powder Coating

START TIME: 8:25

OVEN TEMPERATURE: 300

FINISH TIME: 8:55

210

QC3- Inspect Part Finish

0.00

=) MU 10/10/05



QC

Memo

0.00

1

0

Quality Control

Inspect for foreign object per QSI 024

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Page 8

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220  HandFinish Hand Finishing	HandFinishing  Memo ✓ 1- Install inserts as per Dwg D2750	0.00 0.00	⇒ M 1010105			1	0		
230  HandFinish Hand Finishing	HandFinishing  Memo ✓ 1-Inspect for Foreign Objects ✓ 2-Spray inside of tube with "LPS-3" batch: <u>N/A</u> 3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>M115114</u> EXP DATE: <u>11/01</u> ✓ 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>M114189</u> ✓ 5-Coat all exposed fasteners with "LPS Procyon" batch: <u>M114596</u>	0.00 0.00	⇒ M 1010105			1	0		

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09, 2010 1:16:04 PM

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00		81010106		(X)			
250  Packaging Packaging	Pick Kit  Memo	0.00 0.00							
260  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo *****ensure antiseize is on AN8C21A bolts*****	0.00 0.00		81010108		(X)			

B61913

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**RESEARCH DESIGN AND METHODS**

Page 10

**Accept**

[illegible]

**Setup Start**

**Stop**

[illegible]**Cust Item ID:**[illegible]**Customer:**

**Reference:**

Run Start

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Stop**

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Operation	Description
1	Start
2	Read input
3	Process input
4	Output result
5	End

## Set Up/ Run Hours

**Tool ID**

Tool #

**Plan  
Code**

**Accept Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

270

0.00

**RESEARCH**

## Packaging

### Packaging

## Memo

0.00

### Packaging

Package as per PPP D350-636-011

Ne v 4

280

QC21- Final Inspection - Work Order Release

0.00




## Memo

0.00

QC

## Quality Control

610 12/1/81

10/6/12 

PS 101012  
D

W/O:		WORK ORDER CHANGES					
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# Picklist Print

Thursday, September 09, 2010 1:16:08 PM

Page 1

Work Order ID: 61913

Parent Item: D350-636-011

Parent Item Name: Skidtube LH



Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-23 As per Rev D JLM  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC  
 IPP Rev: M 08-04-22 update steps 4, 13 DD verified by: EC  
 IPP Rev: N 08-09-23 revF as per dwg DD verified by: ec  
 IPP Rev: O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010  
 DD verified by: EC IPP Rev: P 10.06.22  
 revise seq110 DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2594-3 		Manufactured	No			230	Each	147.0000	8	8			
O-Ring, 205 Skidtube													

Location	Loc Qty	Loc Code
FP	147	M61762
55546	19	
58191	12	
59358	116	

D2744 		Manufactured	No			110	Each	18.0000	1	1			
Cap													

Location	Loc Qty	Loc Code
LG	18	
59198	18	

D2600-3-BENT 		Manufactured	No			110	Each	16.0000	1	1			
Extrusion Bent													

Location	Loc Qty	Loc Code
LG	16	
59410	1	
61633	5	
61634	10	

Handwritten notes and signatures:

- Under D2594-3: Jbl 10/10/05
- Under D2744: 18
- Under D2600-3-BENT: 18E 10/09/10
- Under Extrusion Bent: 1 DP 10-9-16

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Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160

Each

203.0000

8

8



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

203

50281

10

57953

2

59111

191

D2739

Manufactured No

160

Each

5.0000

1

1



350 I Beam

Location

Loc Qty

Loc Code

LG

5

61637

5

D3490-3

Manufactured No

160

Each

43.0000

4

4



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

43

60294

6

61218

37

D3490-1

Manufactured No

160

Each

81.0000

4

4



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

81

59424

3

61217

78

W/O:		WORK ORDER CHANGES					
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Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

220

Each

5,329.000

38

38



Insert



HL 10/10/05

Location

Loc Qty

Loc Code

PK011

5329

110768

5329

X38

D3492-041

Manufactured

No

230

Each

49.0000

8

8



Plug Assembly



HL 10/10/05

Location

Loc Qty

Loc Code

FP013

49

59114

1

61311

48

V8

D3793-3

Manufactured

No

230

Each

13.0000

1

1



Wearshoe



HL 10/10/05

Location

Loc Qty

Loc Code

FP18

12

61258

12

X1

FP19

1

57947

1

AN8C35A

Purchased

No

230

Each

40.0000

1

1



BOLT



HL 10/10/05

Location

Loc Qty

Loc Code

FP

1

110847

1

ST346

39

114442

14

115188

25

K1

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Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

D3793-1

Manufactured No

230

Each

14.0000

1

1



Wearshoe



9/10/10/05

Location

Loc Qty

Loc Code

FP18

14

59151

1

59630

1

61244

12

X1

D3488-041

Manufactured No

230

Each

10.0000

1

1



Blade Fitting Assembly, LH



9/10/10/05

Location

Loc Qty

Loc Code

FP

7

53915

7

X1

FP007

3

56052

3

D3794-3

Manufactured No

230

Each

37.0000

1

1



Gasket



9/10/10/05

Location

Loc Qty

Loc Code

FP10

27

60826

1

61712

26

X1

FP18

10

56066

9

59153

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 5

Thursday, September 09, 2010 1:16:09 PM

Work Order ID: 61913

Parent Item: D350-636-011


Parent Item Name: Skidtube LH

Start Date: 9/9/2010

Required Date: 9/17/2010


Start Qty: 1.00

Required Qty: 1.00

AN6C44A Purchased No 230 Each 125.0000 4 4  
  
 BOLT


Location	Loc Qty	Loc Code
FG	2	
103964	2	
ST344	123	
111649	2	
114653	1	
114941	75	
115030	45	

HL 10/10/05

MS21083C8 Purchased No 230 Each 69.0000 1 1  
  
 NUT

Location	Loc Qty	Loc Code
ST303	69	
113845	5	
114934	14	
115594	50	

XL  
 HL 10/10/05

D3536-25 Manufactured No 230 Each 36.0000 1 1  
  
 Gasket

Location	Loc Qty	Loc Code
FP12	36	
59625	10	
61707	26	

HL 10/10/05  
 XL

Thursday, September 09, 2010 1:16:09 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, September 09, 2010 1:16:09 PM

Work Order ID: 61913

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

D3631-1

Manufactured No

230

Each

467.0000

8

8



Washer



10/10/05

Location

Loc Qty

Loc Code

ST072

193

60755

193

V8

ST076

274

52693

206

54388

68

D3791-1

Manufactured No

230

Each

7.0000

1

1



Wearplate



10/10/05

Location

Loc Qty

Loc Code

FP17

7

58573

7

B61702

X1

AN960C10L

NAS1149C0332  
R

Purchased

No

230

Each

155.0000

38

38



washer

M115816



x38 10/10/05

Location

Loc Qty

Loc Code

ST245

155

107534

29

109545

54

111548

72

V38

D2745

Manufactured No

230

Each

165.0000

8

8



Bushing



10/10/05

Location

Loc Qty

Loc Code

ST023

165

52311

5

59112

60

61203

100

X8

Thursday, September 09, 2010 1:16:09 PM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, September 09, 2010 1:16:09 PM

Work Order ID: 61913

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

1,530.000

34

34



Bolt



34 10/10/05

Location

Loc Qty

Loc Code

ST350

1520

114330

11

115015

209

115108

300

115316

300

115371

100

115422

100

115594

500

ST351

10

x34

113121

10

D3537-1

Manufactured

No

230

Each

21.0000

3

3



Wearpad



3 10/10/05

Location

Loc Qty

Loc Code

FP

1

B61640

y3

55465

1

FP17

6

57713

3

60491

3

FP18

14

61201

14

AN960C816L

Purchased

No

230

Each

0.0000

1

1



WASHER

XNAS1149C083B2R/M114915



x1 34 10/10/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, September 09, 2010 1:16:09 PM

Work Order ID: 61913

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

D3492-043

Manufactured No

230

Each

75.0000

8

8



Plug Assembly

Location

Loc Qty

Loc Code

FP

2

54682

2

FP013

73

59117

1

59190

4

61207

8

61503

60

\* B61842

yl 10/10/05

AN3C6A

Purchased

No

230

Each

301.0000

4

4



BOLT

Location

Loc Qty

Loc Code

ST351

301

111982

301

yl

NAS1611-013

Purchased

No

230

Each

232.0000

8

8



O-RING

Location

Loc Qty

Loc Code

FP

232

114451

32

115460

100

115589

100

yl

D3535-25

Manufactured

No

230

Each

9.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP18

9

59623

9

B61706

yl

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Thursday, September 09, 2010 1:16:09 PM

Work Order ID: 61913

Parent Item: D350-636-011


Parent Item Name: Skidtube LH

Start Date: 9/9/2010

Required Date: 9/17/2010


Start Qty: 1.00

Required Qty: 1.00

D3794-1      Manufactured      No      230      Each      32.0000      1      1  
  
 Gasket


Location	Loc Qty	Loc Code
FP010	32	
57942	6	
<u>61704</u>	26	

91 10/10/05


MS21043-6      Purchased      No      230      Each      674.0000      4      4  
  
 NUT


Location	Loc Qty	Loc Code
ST301	674	
<u>112314</u>	674	

X1  
91 10/10/05


D3493-1      Manufactured      No      260      Each      24.0000      2      2  
  
 Washer

Location	Loc Qty	Loc Code
ST065	24	
<u>60873</u>	24	

X4  
2  
10/10/07 

MS21083C8      Purchased      No      260      Each      69.0000      1      1  
  
 NUT

Location	Loc Qty	Loc Code
ST303	69	
113845	5	
114934	14	
<u>115594</u>	50	

2  
2  
10/10/07 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, September 09, 2010 1:16:09 PM

Work Order ID: 61913

Parent Item: D350-636-011


Parent Item Name: Skidtube LH

Start Date: 9/9/2010

Required Date: 9/17/2010


Start Qty: 1.00


Required Qty: 1.00

AN8C21A	Purchased	No	260	Each	33.0000	2	2
							
BOLT							

Location	Loc Qty	Loc Code
----------	---------	----------


ST345	33	
113558	1	
114653	32	

AN960C816L	Purchased	No	260	Each	0.0000	1	2
							
WASHER							

D3672-1	Manufactured	No	230	Each	901.0000	4	4
							
Phenolic Washer							


Location	Loc Qty	Loc Code
----------	---------	----------

ST077	901	
42329	150	
52505	751	

D2741	Manufactured	No	260	Each	45.0000	1	1
							
Blade, 350 Skidtube							

Location	Loc Qty	Loc Code
----------	---------	----------

ST466	45	
57949	7	
60210	38	

D3532-1	Manufactured	No	260	Each	9.0000	2	2
							
Spacer							

Location	Loc Qty	Loc Code
----------	---------	----------

ST068	9	
60510	9	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 11

Thursday, September 09, 2010 1:16:09 PM

Work Order ID: 61913

Parent Item: D350-636-011

Parent Item Name: Skidtube LH



Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

D3672-13

Purchased

No

260

Each

818.0000

2



Phenolic Washer



10/10/17

SP

Location

Loc Qty

Loc Code

ST077

818

54363

818

2

Thursday, September 09, 2010 1:16:09 PM

Shop Packet Print

Page 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

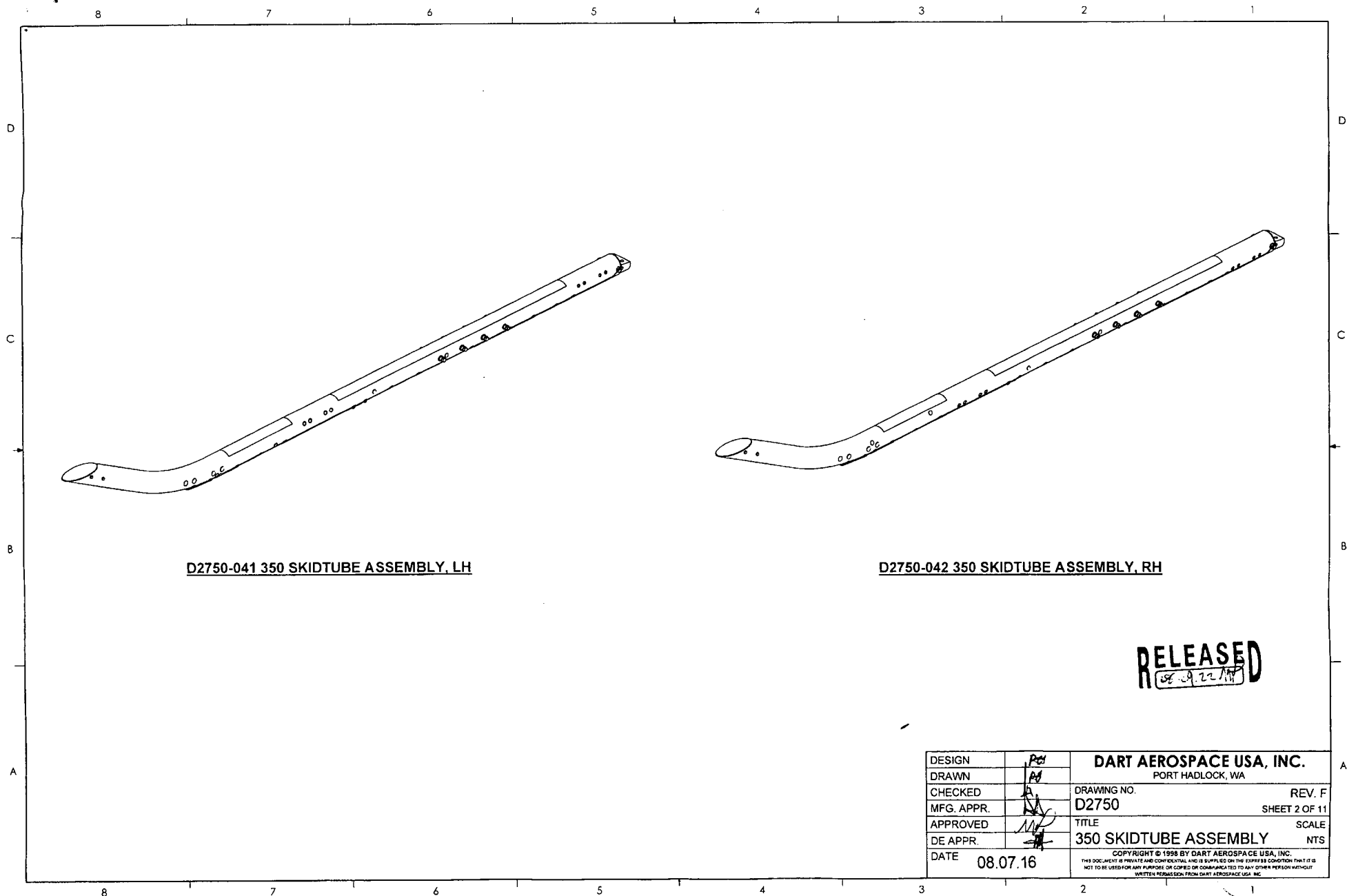
QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
			1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

#### GENERAL NOTES:

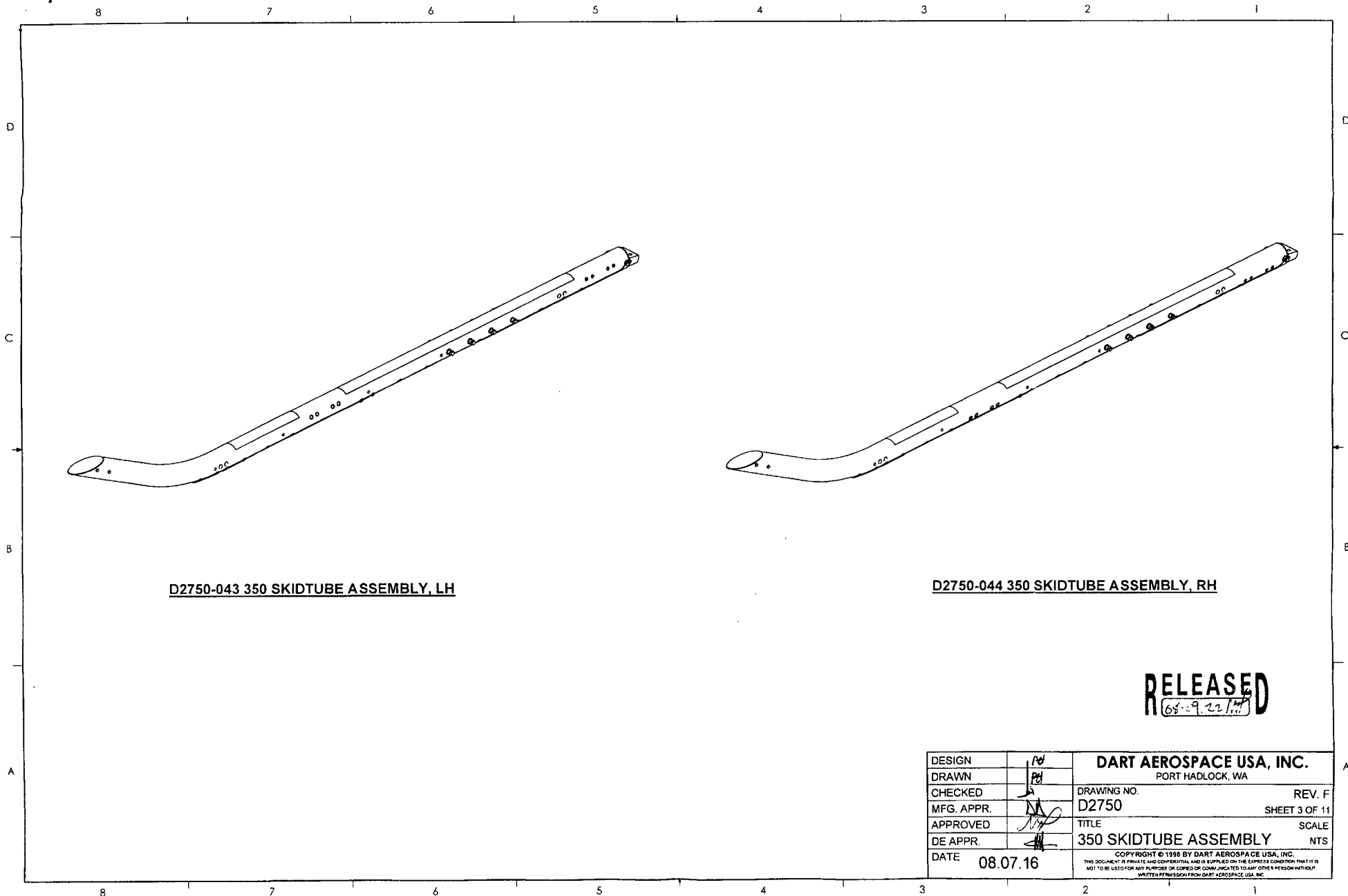
- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

RELEASED  
6-27-22

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		
DART AEROSPACE USA, INC. PORT HADLOCK, WA			
DRAWING NO. D2750		REV. F SHEET 1 OF 11	
TITLE 350 SKIDTUBE ASSEMBLY		SCALE NTS	
COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

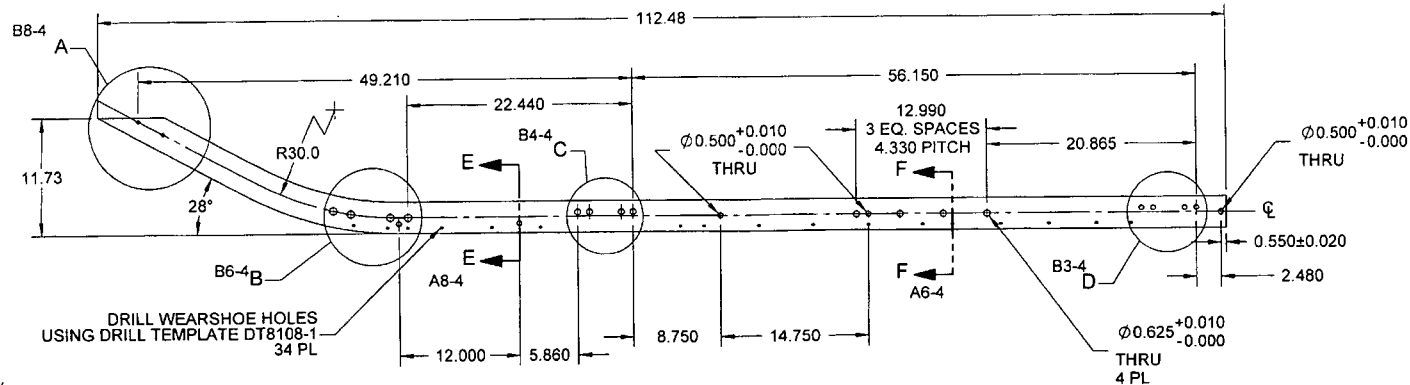




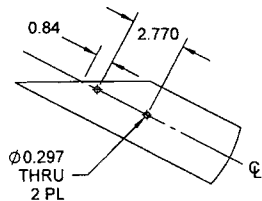


RELEASED  
64-9-22/111

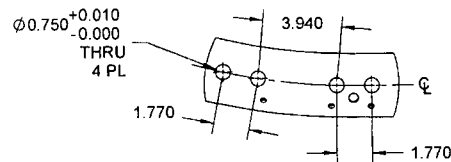
DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 3 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.</small> <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



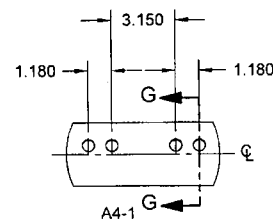
**D2750-1 LH SKIDTUBE**



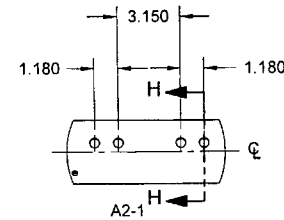
**DETAIL A**  
SCALE 2X



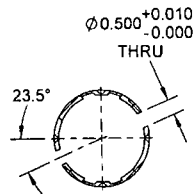
**DETAIL B**  
SCALE 2X



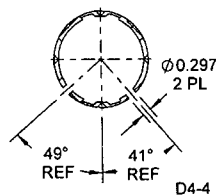
**DETAIL C**  
SCALE 2X



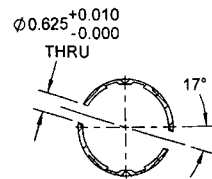
**DETAIL D**  
SCALE 2X



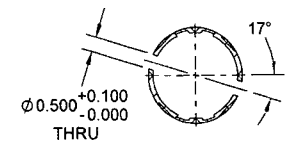
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL

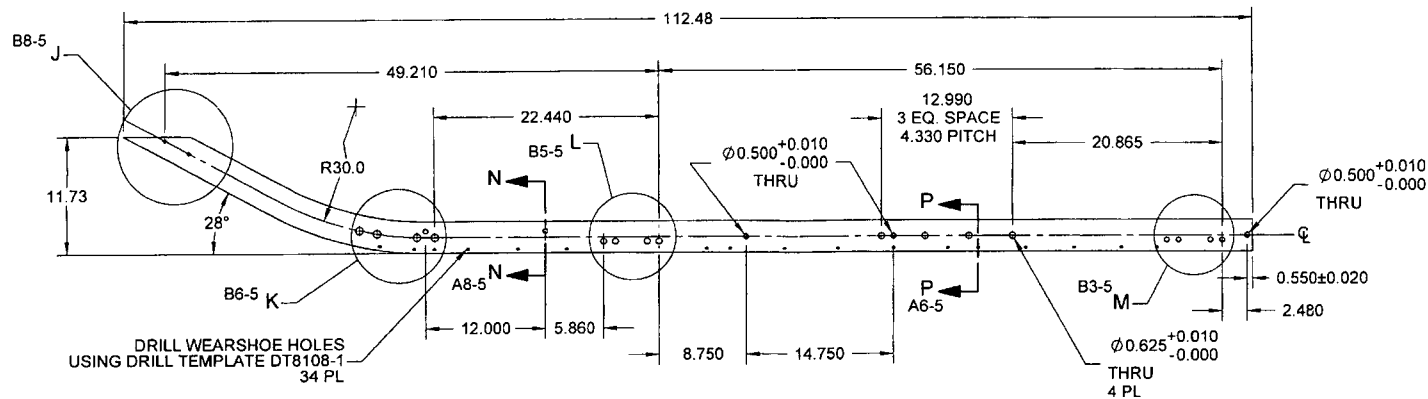


**SECTION H-H**  
SCALE 3X, 4 PL

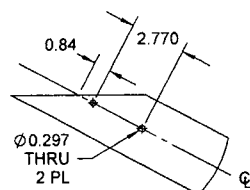
**RELEASED**

DESIGN	IP	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	IP	PORT HADLOCK, WA	
CHECKED		DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.		TITLE	SHEET 4 OF 11
APPROVED		<b>350 SKIDTUBE ASSEMBLY</b>	
DE APPR.		SCALE	
DATE	08.07.16	NTS	

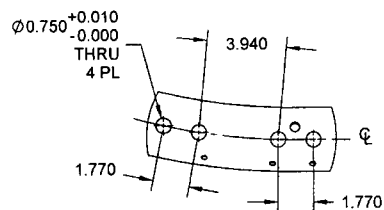
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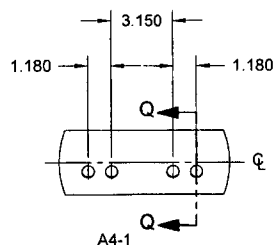
**D2750-2 RH SKIDTUBE**



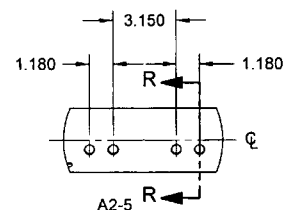
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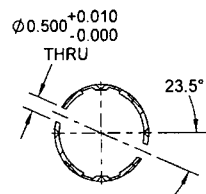
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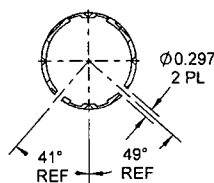
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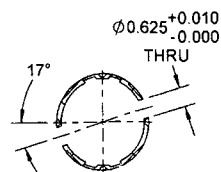
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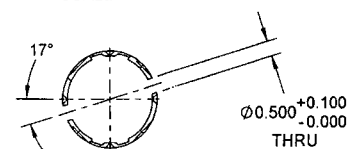
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



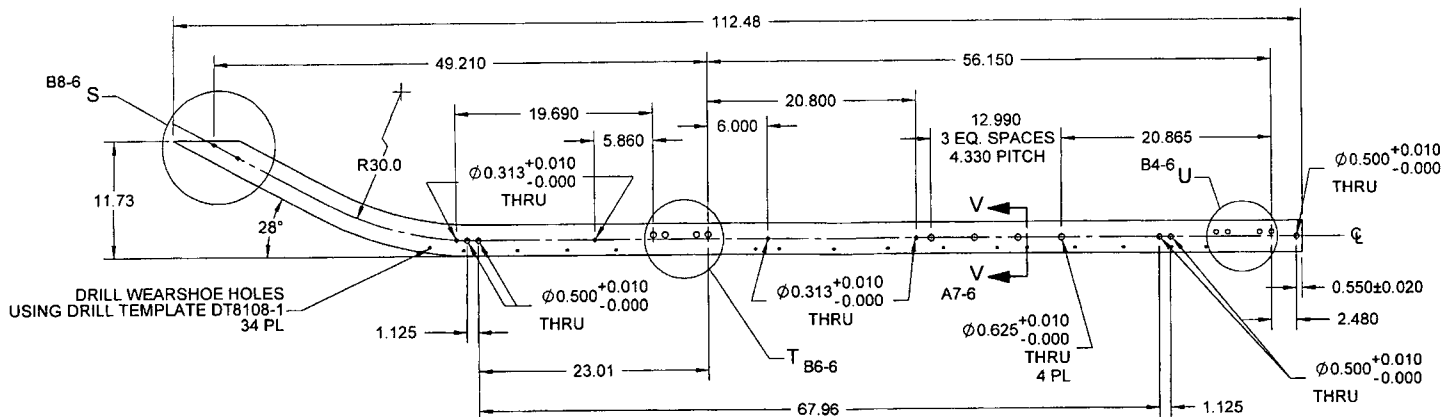
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SCALE 3X, 4 PL



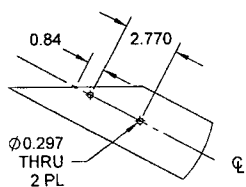
**SECTION R-R**  
SCALE 3X, 4 PL

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APPROVED		<b>350 SKIDTUBE ASSEMBLY</b>	SCALE
DE APPR.			NTS
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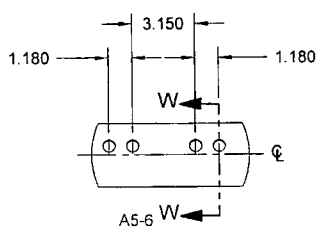
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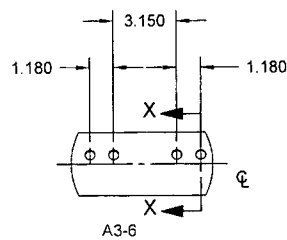
**D2750-3 LH SKIDTUBE**



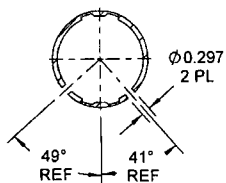
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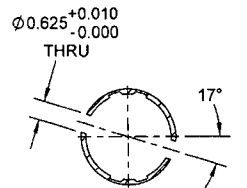
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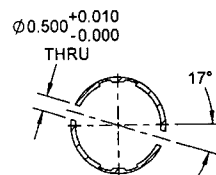
**DETAIL U**  
SCALE 2X



**SECTION V-V**  
SCALE 3X, 17 PL



**SECTION W-W**  
SCALE 3X, 4 PL

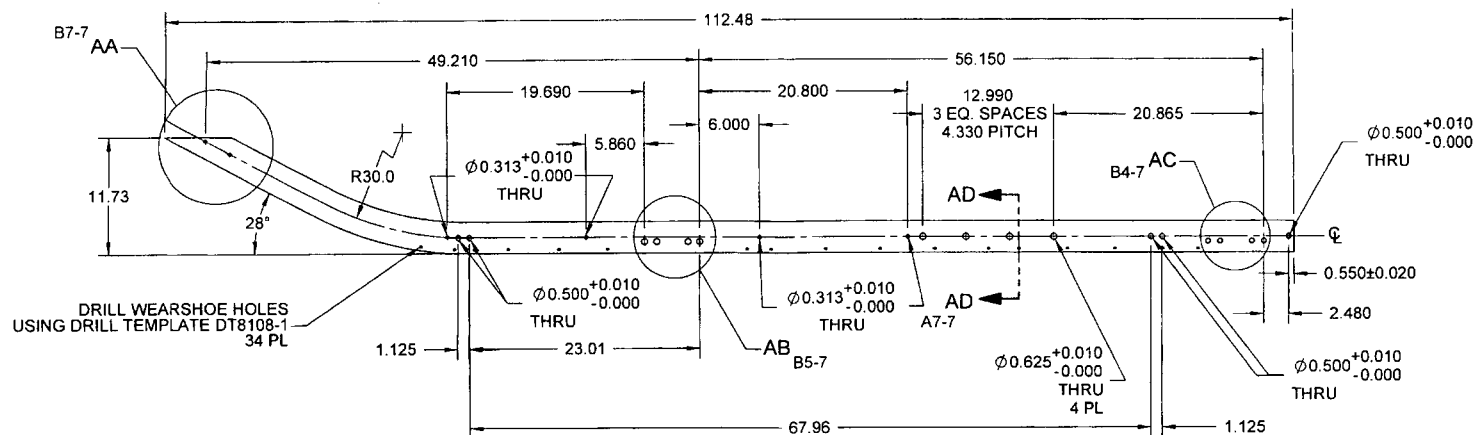


**SECTION X-X**  
SCALE 3X, 4 PL

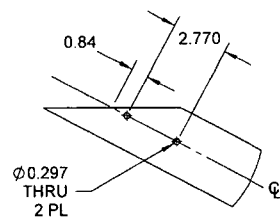
**RELEASED**

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APPROVED		TITLE	SCALE
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DATE	<b>08.07.16</b>	NTS	

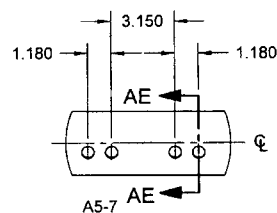
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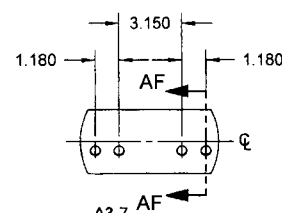
**D2750-4 RH SKIDTUBE**



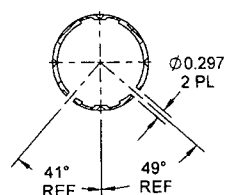
**DETAIL AA**  
SCALE 2X  
D7-7



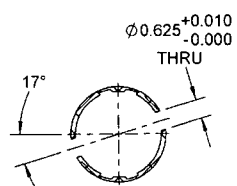
**DETAIL AB**  
SCALE 2X  
C4-7



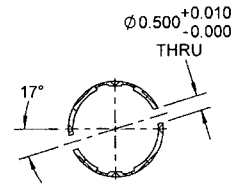
**DETAIL AC**  
SCALE 2X  
D3-7



**SECTION AD-AD**  
SCALE 3X, 17 PL  
D3-7



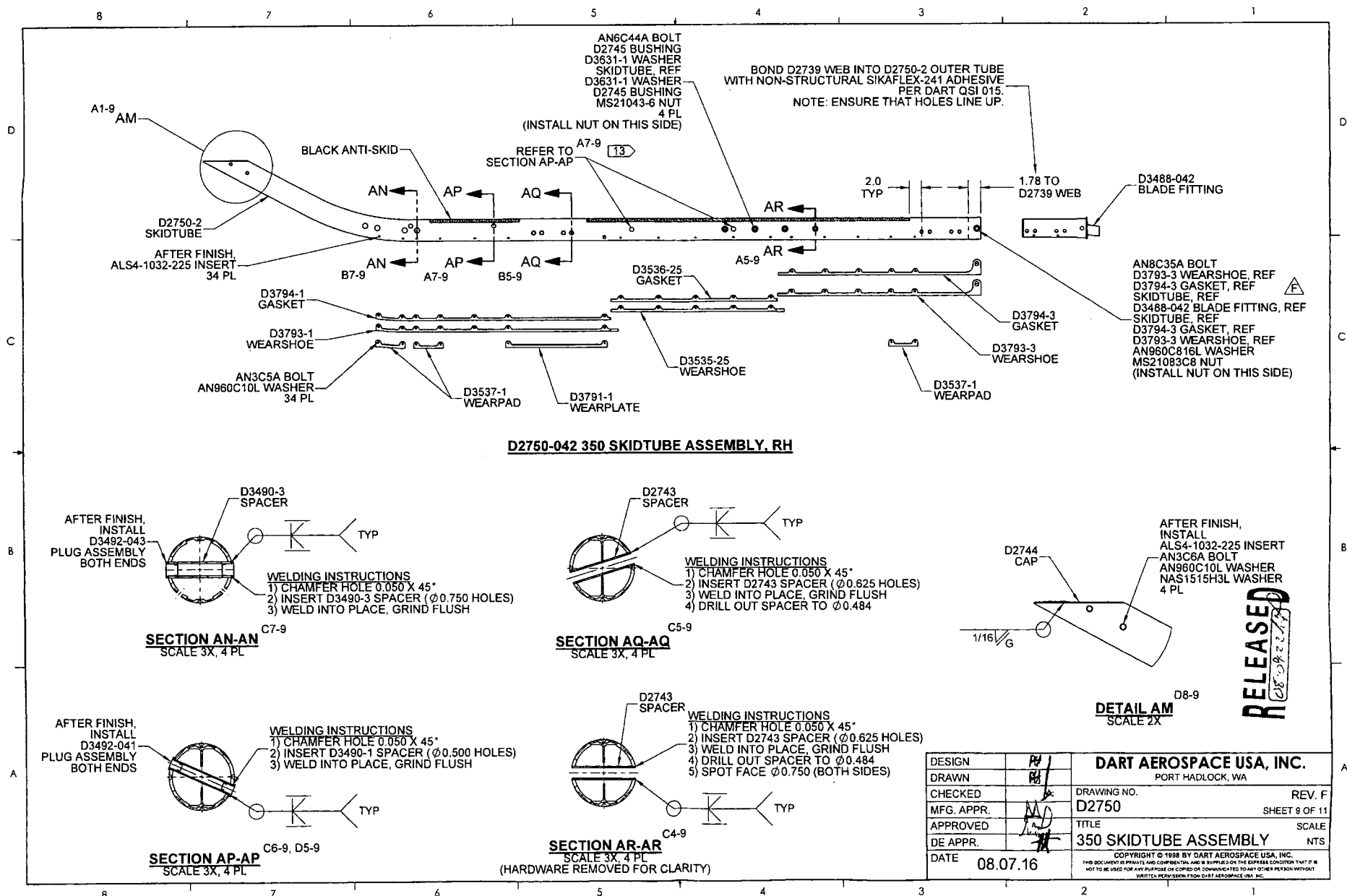
**SECTION AE-AE**  
SCALE 3X, 4 PL  
B6-7

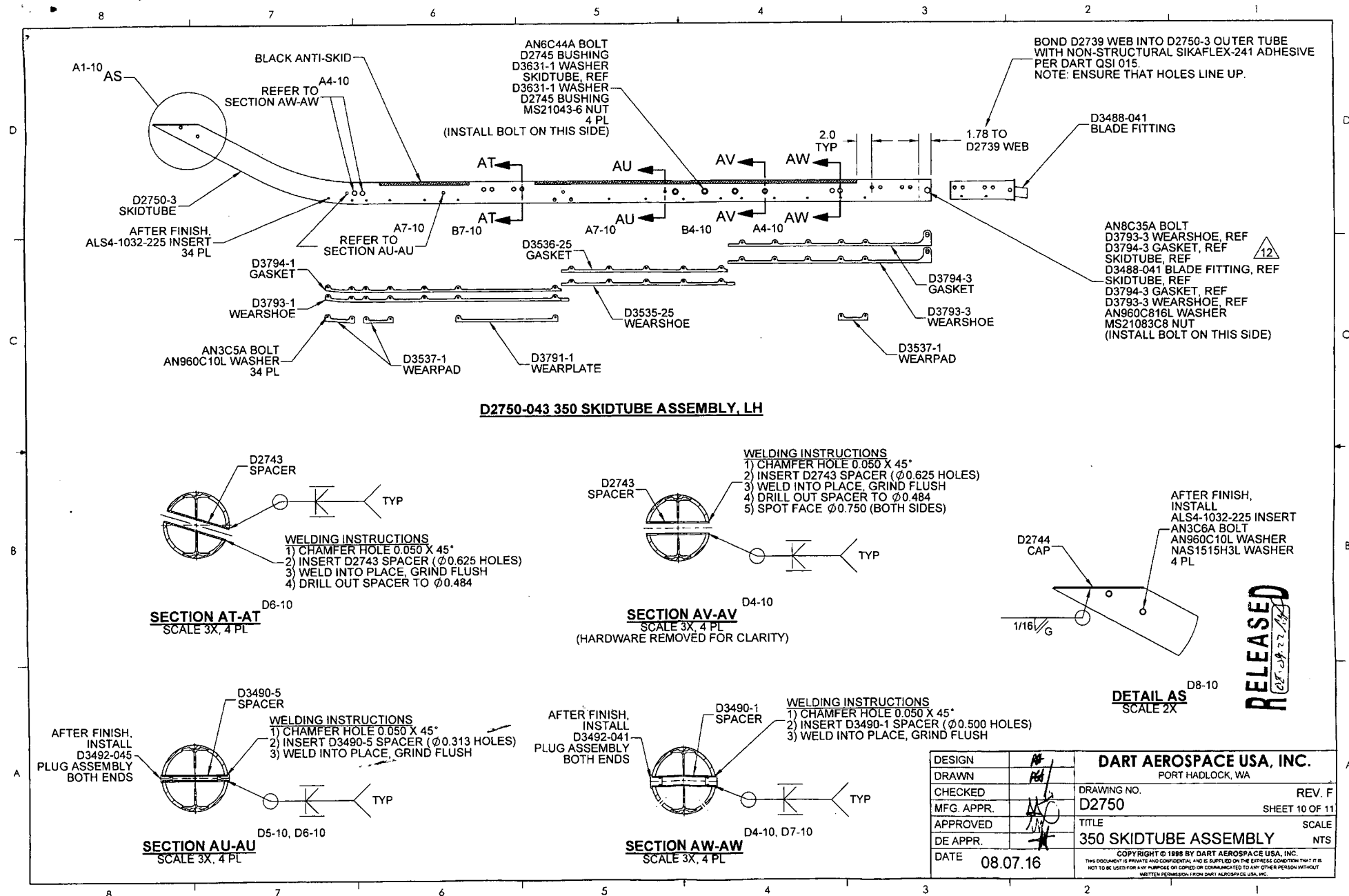


**SECTION AF-AF**  
SCALE 3X, 4 PL  
B4-7

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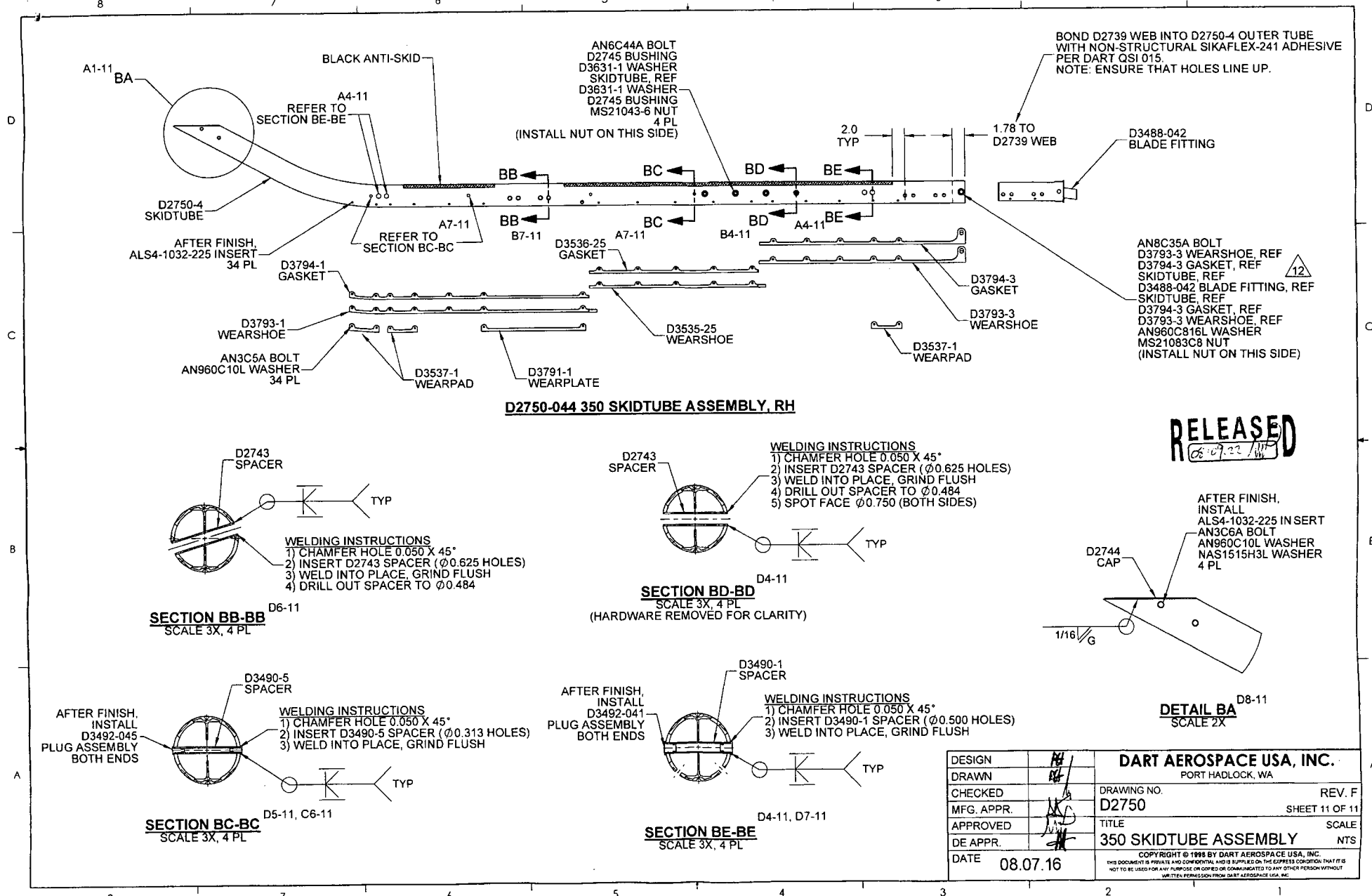
5

4

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2

1





NO. 236

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 60988  
Part number: D350-636-012  
Description: 350 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier [Signature] Date of Test Coupon 10.08.12

Welder [Signature] Date of Test Coupon 10.08.12

The above named individual is qualified in accordance with AWS D17.1.2001 to weld